

Date: Wednesday, 03/06/2009 8:17:23 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 48339		
Estimate Number	: 13999		
P.O. Number	:	Part Number	: D39435
This Issue	: 03/06/2009 S.O. No. :	Drawing Number	: D3943 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: <u>09-06-03</u>	Due Date	: 10/06/2009 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 09-06-03 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010B0375X03500	1010-1025 Steel Bar .375 x 3.500
-----	------------------	----------------------------------



Comment: Qty.: 0.1313 f(s)/Unit Total: 0.2625 f(s)
 1010-1025 Steel Bar .375 x 3.500
 BATCH: 106317 B9-6-3

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3943
 Dwg Rev: A
 Prog Rev: A

B9-6-3

②

2-Deburr if necessary B9-6-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

ml 04/06/03

②

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 1-OPEN TO TAP DRILL SIZE FOR 5/8" THREAD
 2-DRILL TAP 1/4"-28 AS PER DWG
 3-MILL RAD

ml 04/06/03

②

Date: Wednesday, 03/06/2009 8:17:23 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 48339

Part Number: D39435

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-06-03 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Dan Stow

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

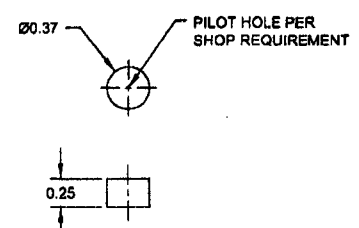
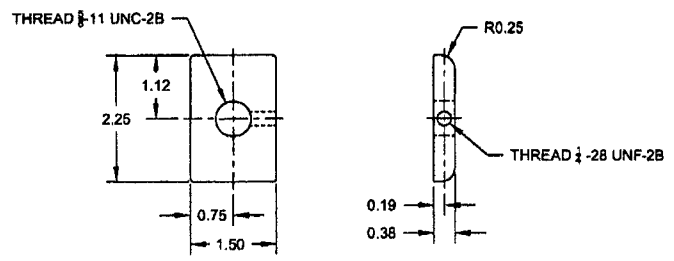
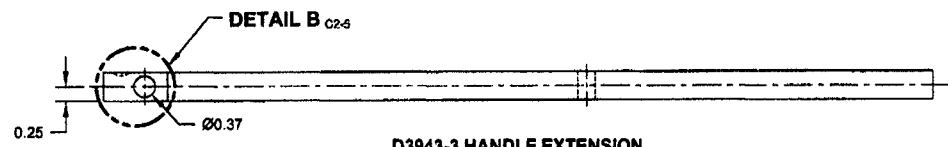
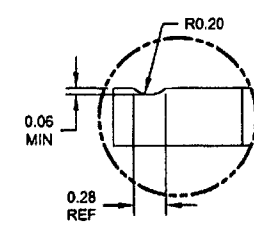
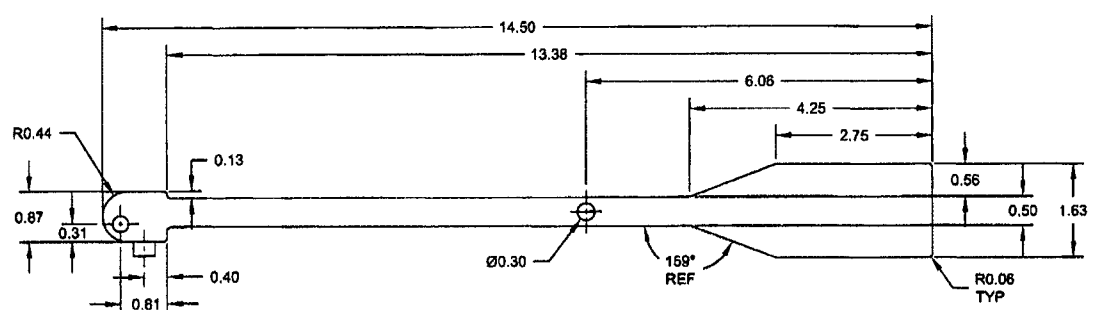
09/06/04

Job Completion



mf 09-06-03

8 7 6 5 4 3 2 1



NOTES -11/-13:

- 1) MATERIAL -3 & -5: MILD STEEL, SHEET
 AISI 1010-1025 OR ASTM A36/A366/A1008
 OR CSA G40-21, 38W/44W/50W/60W/70W
 REF DART SPEC M1010-S
- OR : MILD STEEL, BAR
 AISI 1010-1025 OR ASTM A36/A366/A569/A570
 OR CSA G40-21, 38W/44W/50W/60W/70W
 REF DART SPEC M1010-B
- 7: MILD STEEL, ROUND BAR
 AISI 1018-1025
 PER MIL-S-7097
 REF DART SPEC M1018-R

- 2) FINISH -3: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 PARTS INDICATED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A

48339

RELEASED

DESIGN	OSTOW / AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3943	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	09.05.13	<small> COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD </small>	

8 7 6 5 4 3 2 1